

Date: Monday, 12/01/2009 2:36:31 PM  
 User: Julie Dawson

# 6 Rev Process Sheet

|  |   |
|--|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : WEARPLATE                             |
| <b>Job Number</b> : 44642  |   |
| <b>Estimate Number</b> : 12467   |   |
| <b>P.O. Number</b> :   | <b>Part Number</b> : D35121                                 |
| <b>This Issue</b> : 12/01/2009 <b>S.O. No.</b> :   | <b>Drawing Number</b> : D3512 REV C                         |
| <b>Prsht Rev.</b> : NC   | <b>Project Number</b> : N/A                                 |
| <b>First Issue</b> : / / <b>Type</b> : SMALL / MED FAB   | <b>Drawing Revision</b> : C                                 |
| <b>Previous Run</b> : 42532  | <b>Material</b> :   |
| <b>Written By</b> :  | <b>Due Date</b> : 30/01/2009 <b>Qty:</b> 20 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JUD 09.01.13</u>   |   |
| <b>Comment</b> : Est Rev:A New Issue 06-06-20 JLM<br>Est Rev:B Now SS as per Rev B 06-12-15 JLM<br>Est Rev:C Rev C dwg 07-12-06 DD |   |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 Sheet .063 |
|-----|-----------|--------------------|



MAT NOT PULLED



**Comment:** Qty.: 0.2741 sf(s)/Unit Total : 5.4810 sf(s)  
 304 SS .063" THK (16 GA)  
 (M304S16GA)  
 Batch: 109057 IB 9-1-29

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3512  
 Dwg Rev: C  
 Prog Rev: C

IB 9-1-29

(22)

2-Deburr if necessary IB 9-1-29

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



IB 9-1-29

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



09.01.30 (22)

**Comment:** SECOND CHECK

|     |          |          |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



**Comment:** NC BRAKE  
 Deburr if necessary  
 Form as per dwg D3512 using DT8179

09/02/05

(22)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:36:31 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 44642

Part Number: D35121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/02/05 (22) *count*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004

Qty Description Batch

A/R 2059b Hardcoat Rod *M109893*

*FZ 9-2-17 X22*

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*209-02-17 (22)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*209-02-17 (22)*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: *10:30am*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *11:00am*

*HL 09-02-19 (22)*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*BL 09-02-19 (22)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *498*

*9/2/20*

*SD*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:36:31 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 44642

Part Number: D35121

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/23 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

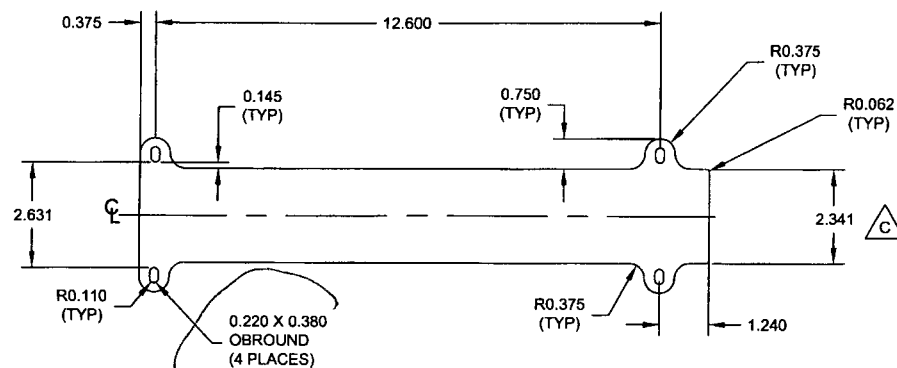
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

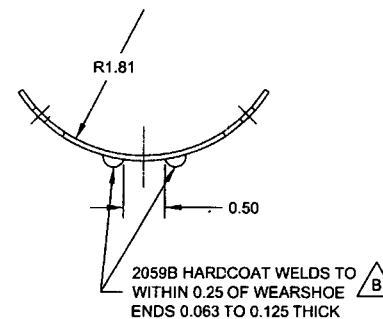
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





**D3512-1F FLAT PATTERN**



**SECTION A-A**  
SCALE 2:3



**D3512-1 BENDING DETAIL**

**RELEASED**  
07-11-16

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

| C          | ENLARGE OBOURD FOR EASIER ASSEMBLY<br>UPDATE DRAWING FORMAT<br>ADD WEIGHT | PH | 07.10.05 |
|------------|---|----|----------|
| B          | CHANGE MATERIAL TO STAINLESS STEEL  | PH | 06.10.27 |
| A          | NEW ISSUE   | PH | 06.04.21 |
| REV.       | DESCRIPTION   | BY | DATE     |
| DESIGN     |   |    |          |
| DRAWN      |   |    |          |
| CHECKED    |   |    |          |
| MFG. APPR. |   |    |          |
| APPROVED   |   |    |          |
| DE APPR.   |   |    |          |
| DATE       | 07.10.05  |    |          |

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3512  
REV. C  
SHEET 1 OF 1

TITLE WEARPLATE  
SCALE 1:3

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